

Date: Thursday, 6/21/2007 2:29:08 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPLATE
 Job Number : 33055
 Estimate Number : 10288
 P.O. Number : NA Part Number : D25771
 This Issue : 6/21/2007 S.O. No. : NA Drawing Number : D2577 REV E
 Prsht Rev. : NC Project Number : N/A
 First Issue : NA Type : SMALL /MED FAB Drawing Revision : E
 Previous Run : 32649 Material : NA
 Due Date : 7/10/2007 Qty: 30 Um: Each
 Written By :
 Checked & Approved By : 07 06 22
 Comment : Est: E 02.09.24 Re-format; Incorporated D2577-101-11 K
 J/R/F
 est F 06.09.11 now waterjet EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1010S16GA 1010/1025/A21/6aA SHEET



Comment: Qty.: 0.8474 sf(s)/Unit Total : 25.4205 sf(s)
 1010/1025/A21/6aA SHEET

B# M104948

B 07-07-22

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D2577 (D2577-101 detail)
 Dwg Rev: E
 Prog Rev: E

(30)

2-Deburr if necessary

B 07-07-22

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B 07-07-22

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

B 07-07-22

(30)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE
 1-Form on brake as per Dwg D2577 using DT8155 and DT8179
 2-Form joggle as per Dwg D2577 using DT8157
 3-Identify as D2577-1
 4-Deburr if nesasary

FF 07-08-08

30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/08/28
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 6/21/2007 2:29:09 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 33055

Part Number: D25771

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

EP 07/08/08

created

(30)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using DT8308A & DT8308B as per Dwg D2577

Qty Description

Batch

A/R 7560 Hardcoat Rod

M104721 / M105138 FC 07/08/23 (30)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/08/27 (30)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M-1 07/08/28

(30X)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

EP 07/08/28 (30)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: EP-15

EP 07/08/28 (30)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D 07/08/28

Job Completion



h 07/08/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
00.09.22

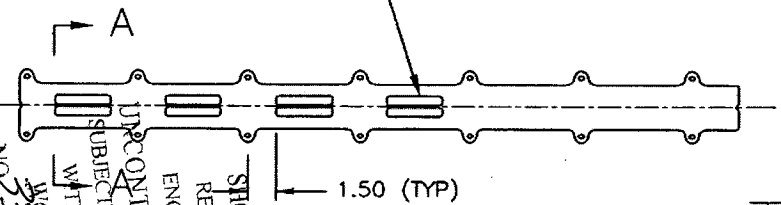
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CHECKED	APPROVED	HAMKESBURY, ONTARIO, CANADA
DATE	TITLE	REV. E
00.09.22	WEARSHOE	SHEET 1 OF 5
A	NEW ISSUE	SCALE
B	ADD HARDCOAT WELDS	1:10
C	CHANGE HOLES TO OBROUNDS	
D	CORRECTED DIMENSIONS ON -1 & -3	
E	ADD D2577-101/-11/-13 INCORPORATE DE09176	

7560 HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308

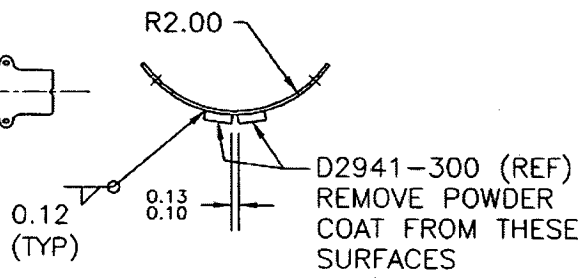


D2577-1 & D2577-3 WEARSHOE
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D2941-300
SHWAYDER WEAPADS
(8 PLACES)



SECTION A-A
SCALE 1:5



D2577-21 & D2577-23 WEARSHOE
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

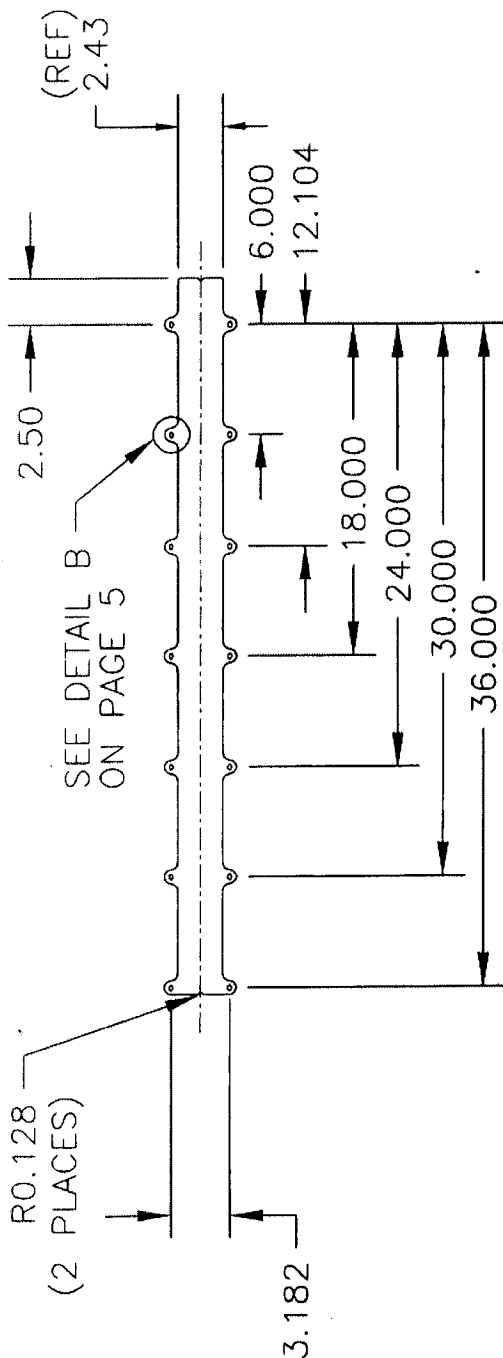
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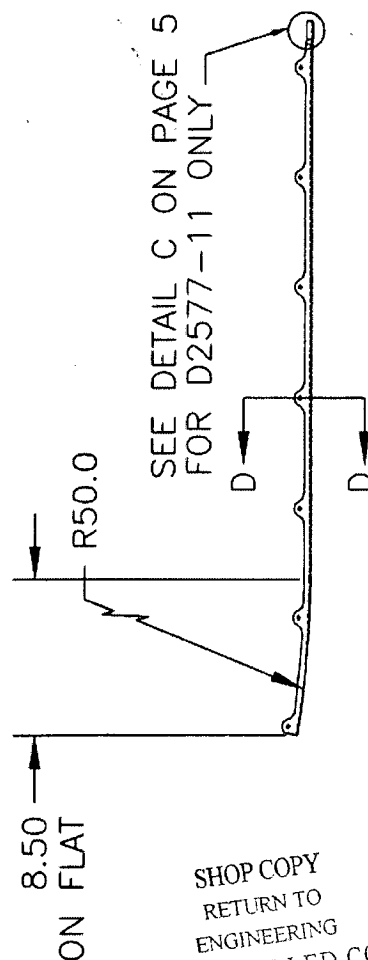


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CHECKED #	APPROVED #	DRAWING NO. D2577	REV. E SHEET 2 OF 5
DATE 00.09.22		TITLE WEARSHOE	SCALE 1:10

RELEASED
00.09.26 #



D2577-101 FLAT PATTERN
BREAK ALL SHARP CORNERS 0.010 TO 0.020
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
SERIES STEEL 0.063 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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D2577-11 & D2577-13 LONGITUDINAL BEND
MAKE FROM D2577-101
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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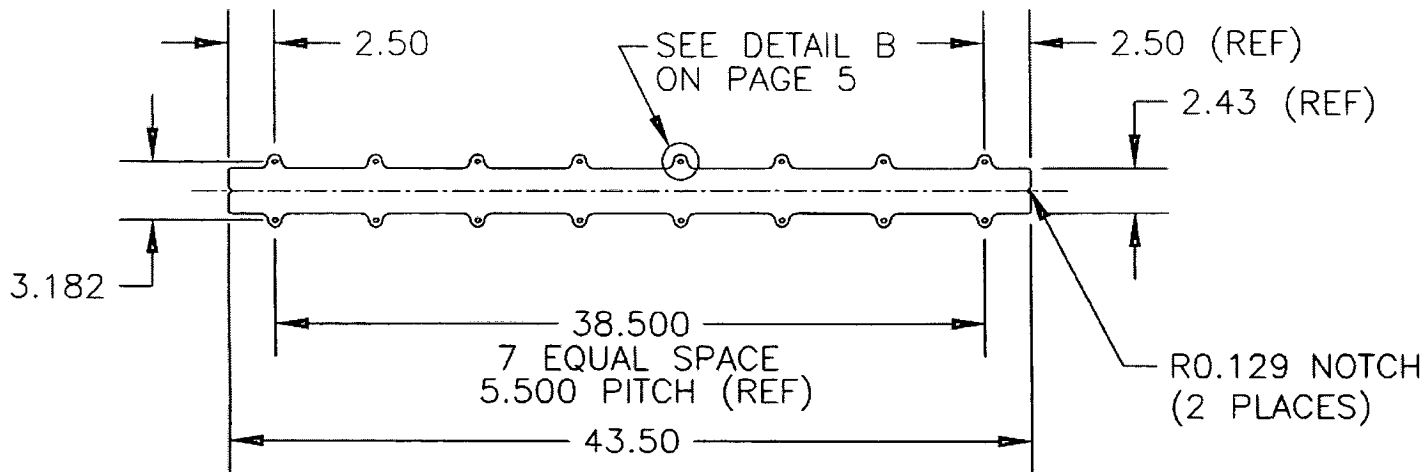
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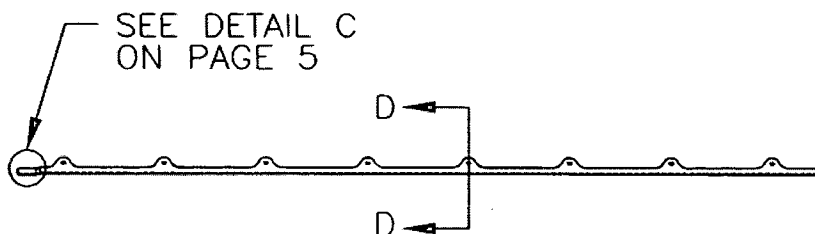
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CHECKED	<i>CP</i>	APPROVED	<i>CP</i>	
DATE	00.09.22	DRAWING NO.	D2577	
TITLE				WEARSHOE
SCALE				1:10

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00.07.26

D2577-5 FLAT PATTERN



D2577-5 LONGITUDINAL BEND



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D2577-5 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

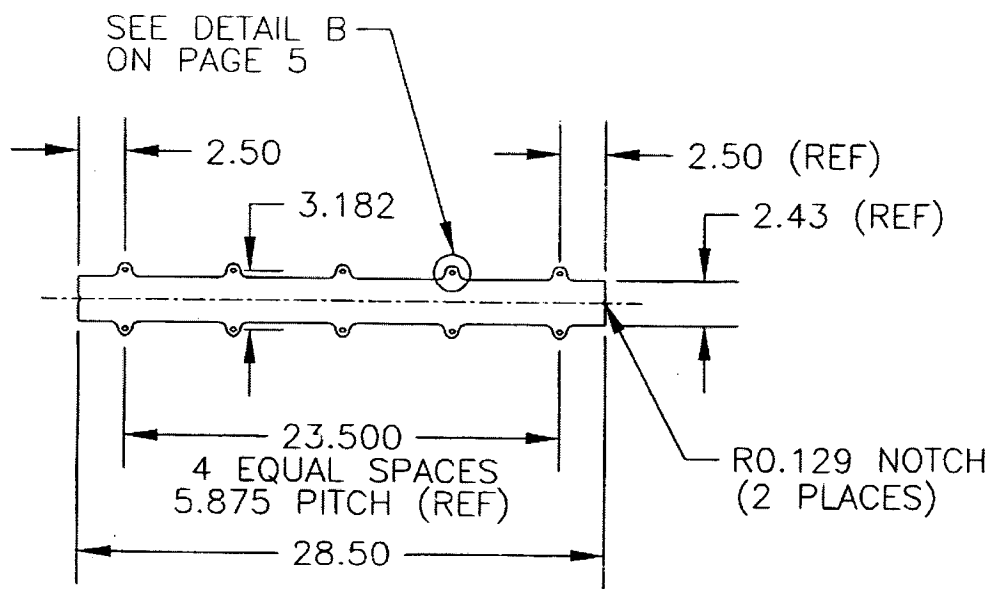
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TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

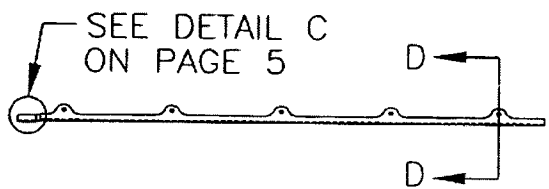


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DATE	TITLE	DRAWING NO.
00.09.22	WEARSHOE	D2577
		SHEET 4 OF 5
	SCALE	REV. E
	1:10	

D2577-7 FLAT PATTERN



D2577-7 LONGITUDINAL BEND



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D2577-7 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
SERIES STEEL 0.063 THICK
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

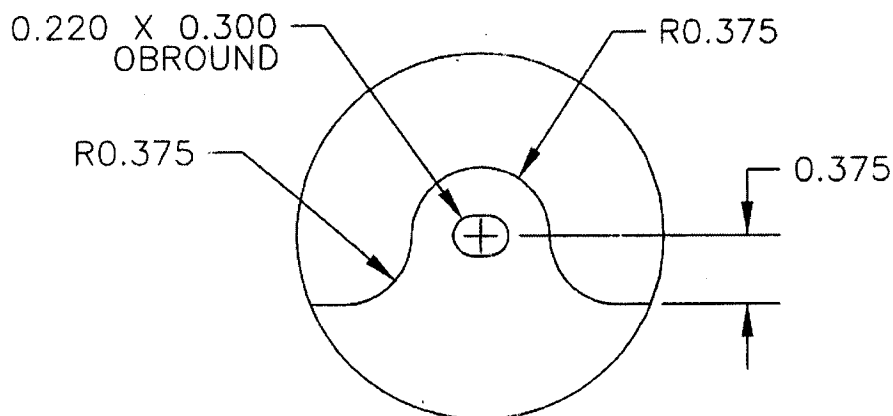
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00.09.26



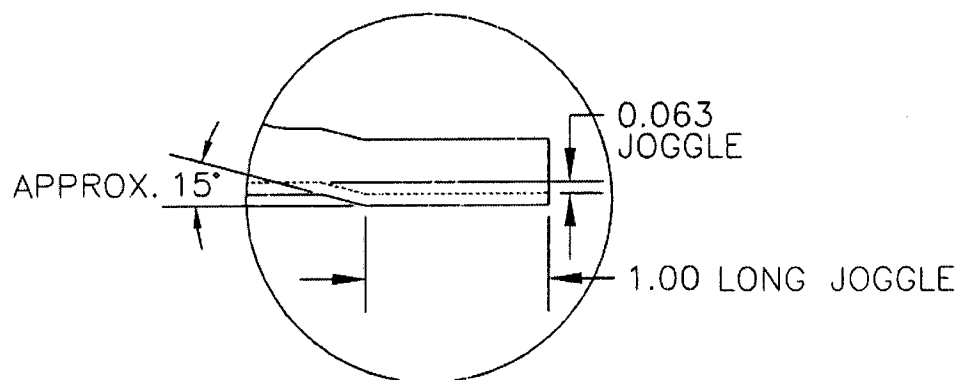
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CHECKED #	APPROVED #	DRAWING NO. D2577	REV. E SHEET 5 OF 5
DATE 00.09.22		TITLE WEARSHOE	SCALE 1:10

RELEASED
00.09.26

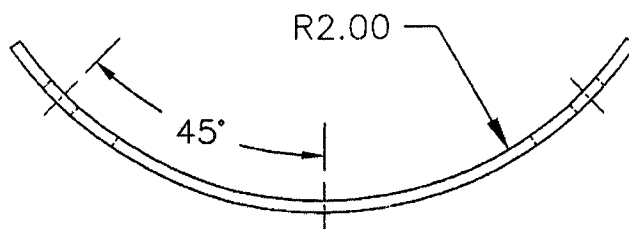
DETAIL B (SCALE 1:1)



DETAIL C (SCALE 1:1)



SECTION D-D (SCALE 1:1)



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